second layer **26** of batter was poured over the filling material **14** and the waffle iron was closed. The waffle iron was closed for 90 seconds and was set at a temperature of 205° C. Such waffle irons are well known in the art.

[**0056**] The ratio of the uncooked batter to the filling material **14** preferably ranges from 2:1 to 8:1. Optimally, the ratio of the uncooked batter to the filling material **14** is five parts batter to one part of filling material **14**. For a five to one ratio, two and one half parts of batter is poured into a lower portion of a waffle iron, one part of the filling material **14** is deposited on top of the batter, and the last two and one half parts of batter poured over, concealing the filling material **14**.

[**0057**] The components of the filling material **14** were mixed in a conventional manner as would be understood by one of ordinary skill in the art.

[**0058**] The batter are mixed in a conventional manner. Typically water and flour will be mixed first in a production mixing tank. The other components of the batter are added to the tank as desired. The batter should be mixed at a high speed until a homogeneous batter has been obtained.

EXAMPLE 1

[**0059**] Fruit filled waffles **10** were prepared, as described above, using the batter shown in Table 3 and the filling shown in Table 4, all weights based on the total weight of the batter or the filling. The components have been used in the ranges shown and suitable products have been formed:

TABLE 3

Batter Material	Percent by Weight
Water	40–45%
Hard Wheat Flour	35–40%
Shortening	6–15%
Liquid Whole Egg	3–7%
Whey	0.5–3%
Granulated Sugar	1–5%
Baking Soda	0.5–1%
Sodium Aluminum Phosphate	0.4–0.7%
Salt	0.25–1%
Monocalcium Phosphate	0.1–0.5%

[**0060**]

TABLE 4

Filling Material	Percent by Weight
Water	20–25%
Sweeteners	40–45%
Fruit Flakes	2–10%
Instant Modified Starch	2–5%
Citric Acid	0.2–0.5%
Fruit Flavoring	0.2–0.5%
Xanthan Gum	0.1–0.5%
Emulsifier	0.2–0.5%
Powdered Malic Acid	0.1–0.4%
Caramel Coloring	0.1–0.4%
Ground Cinnamon	0.1–0.5%
Salt	0.1–0.5%

[**0061**] The resulting filled waffle **10** can be frozen for up to nine months or more and yet retain the fresh-like qualities for the consumer. The packaging necessary for freezer storage includes, but is not limited to sealing the waffle **10** in an airtight wrapper. Sealing the filled waffle **10** in an airtight wrapper will prolong the maximum recommended storage period but is not necessary for short-term storage.

[**0062**] The filled waffle **10** is intended to be heated in an upright toaster until browned and warmed for consumption.

EXAMPLE 2

[**0063**] Sweet flavor filled waffles **10** were prepared using an alternative filling material **14** wherein the filling is a maple flavored filling presented in Table 5, below. The batter was prepared as described above and the waffles were prepared as described above.

TABLE 5

Filling Material	Percent by Weight
Water	1–50%
Sweeteners	35–80%
Fat	0–15%
Starch	0.5–5%
Xanthan Gum	0.1–3%
Maple Flavoring	0.01–5%
Maple Syrup	0–20%
Acidulant	0.01–5%
Caramel Coloring	0.01–5%
Antimycotic preservative	0.05–1%
Emulsifier	0–1%
Salt	0.05–2%

[**0064**] The components are as described above.

EXAMPLE 3

[**0065**] Cheese filled waffles **10** were prepared using the filling formulation below, the batter described above, and assembled as described above. Examples of useful cheeses include, but are not limited to, cream cheese, imitation cheese, cheese powder, american cheese, asagio cheese, baker's cheese, blue cheese, cheddar cheese, fortina cheese, monterey jack cheese, mozzarella cheese, parmesan cheese, provolone cheese, ricotta cheese, romano cheese, swiss cheese, and mixtures thereof. The dairy cream may include, but is not limited to, whole dairy cream, evaporated dairy cream, powdered dairy cream, dairy analogs, and mixtures thereof.

TABLE 6

Filling Material	Percent by Weight
Sweeteners	10–50%
Cheese	0.5–30%
Egg	0–10%
Fat	5–30%
Emulsifier	0–1%
Xanthan Gum	0.025–0.20%
Dairy Cream	0–10%
Starch	0.5–5%
Antimycotic preservative	0.05–1%
Flavoring	0.01–5%
Salt	0.05–5%

[**0066**] The other components are as described above.

[**0067**] The invention has been described in an illustrative manner, and it is to be understood that the terminology